

READ THIS FIRST



For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Model T32253/T32254

IMPORTANT UPDATE

For Machines Mfd. Since 08/20
and Owner's Manual Printed 11/20

The following corrections have been made since the owner's manual was printed:

- The Model T32253 buffing wheel hex nuts are 1/2"-12, not 1/2"-13.
- The work light does not come pre-installed on the buffer.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Specifications

Main Specifications:

Spindle

Spindle Thread Pitch12 TPI

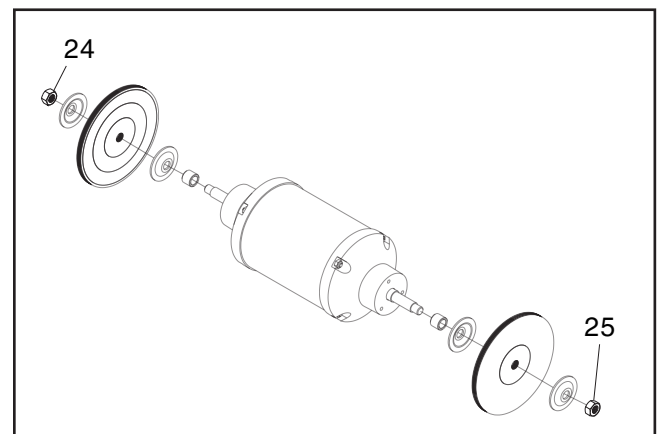
Revised Needed for Setup

Description	Qty
• Safety Glasses (for each person)	1
• Solvent/Cleaner.....	1
• Disposable Rags	1
• Disposable Gloves	1
• Phillips Head Screwdriver #1	1
• Open-End Wrench 3/4" (T32253).....	1
• Open-End Wrench 29/32" (T32254)	1
• Open-End Wrench 17mm	1
• Electrical Tape.....	As Needed

Revised Tools Needed for Installing/ Removing Buffing wheel

Tools Needed	Qty
Open-End Wrench 3/4" (T32253).....	1
Open-End Wrench 29/32" (T32254)	1

T32253 Revised Parts



REF	PART #	DESCRIPTION
24	PT32253024	HEX NUT 1/2-12 LH
25	PT32253025	HEX NUT 1/2-12

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#CS21920 PRINTED IN TAIWAN

Revised Inventory

Box 1 (Figure 1)	Qty
A. Buffer.....	1
G. Work Light	1

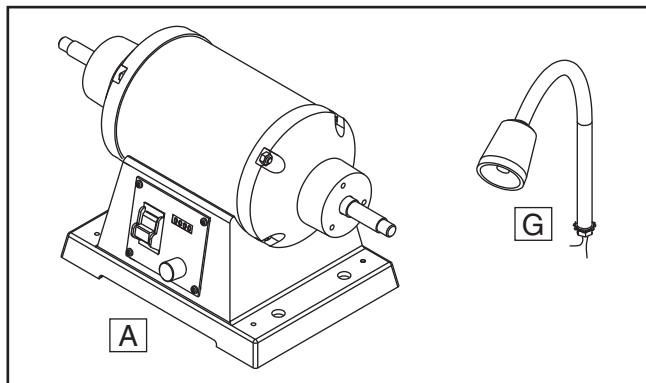


Figure 1. Revised inventory.

Installing Work Light

After assembling your buffer using the **Assembly** section on **Page 16** of the owner's manual, install the work light using the steps below.

Items Needed	Qty
Phillips Head Screwdriver #1	1
Open-End Wrench 17mm.....	1
Electrical Tape.....	As Needed

To install work light:

1. Remove flange screw and junction box cover shown in **Figure 2**.



Figure 2. Location of junction box cover and flange screw.

2. Loosen wire nuts indicated in **Figure 3**.



Figure 3. Location of wire nuts.

3. Use pre-installed hex nut, lock washer, and external tooth washer on work light to attach work light to top of junction box (see **Figure 4**).
4. Use wire nuts from **Step 2** to connect work light wires shown in **Figure 4** (refer to wiring diagrams beginning on **Page 27** in owner's manual. Twist wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose during operation.

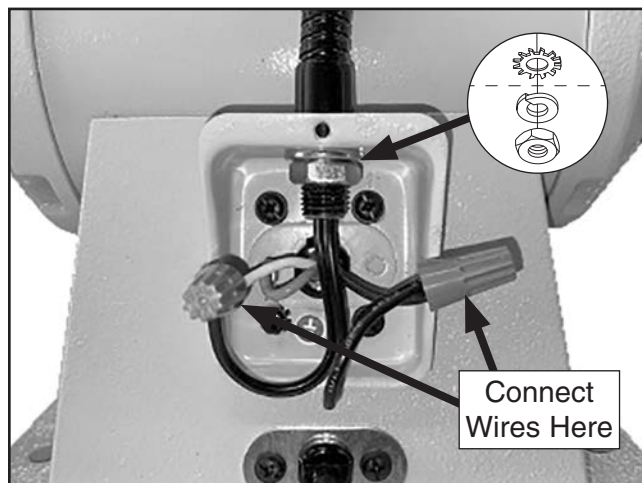


Figure 4. Work light connected to buffer wiring.

5. Install junction box cover and flange screw removed in **Step 1**.
6. Proceed to **Test Run** beginning on **Page 17** of owner's manual.





MODEL T32253/T32254
VARIABLE-SPEED BUFFER
w/WORK LIGHT
OWNER'S MANUAL
(For models manufactured since 08/20)



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V1.11.20



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com


Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

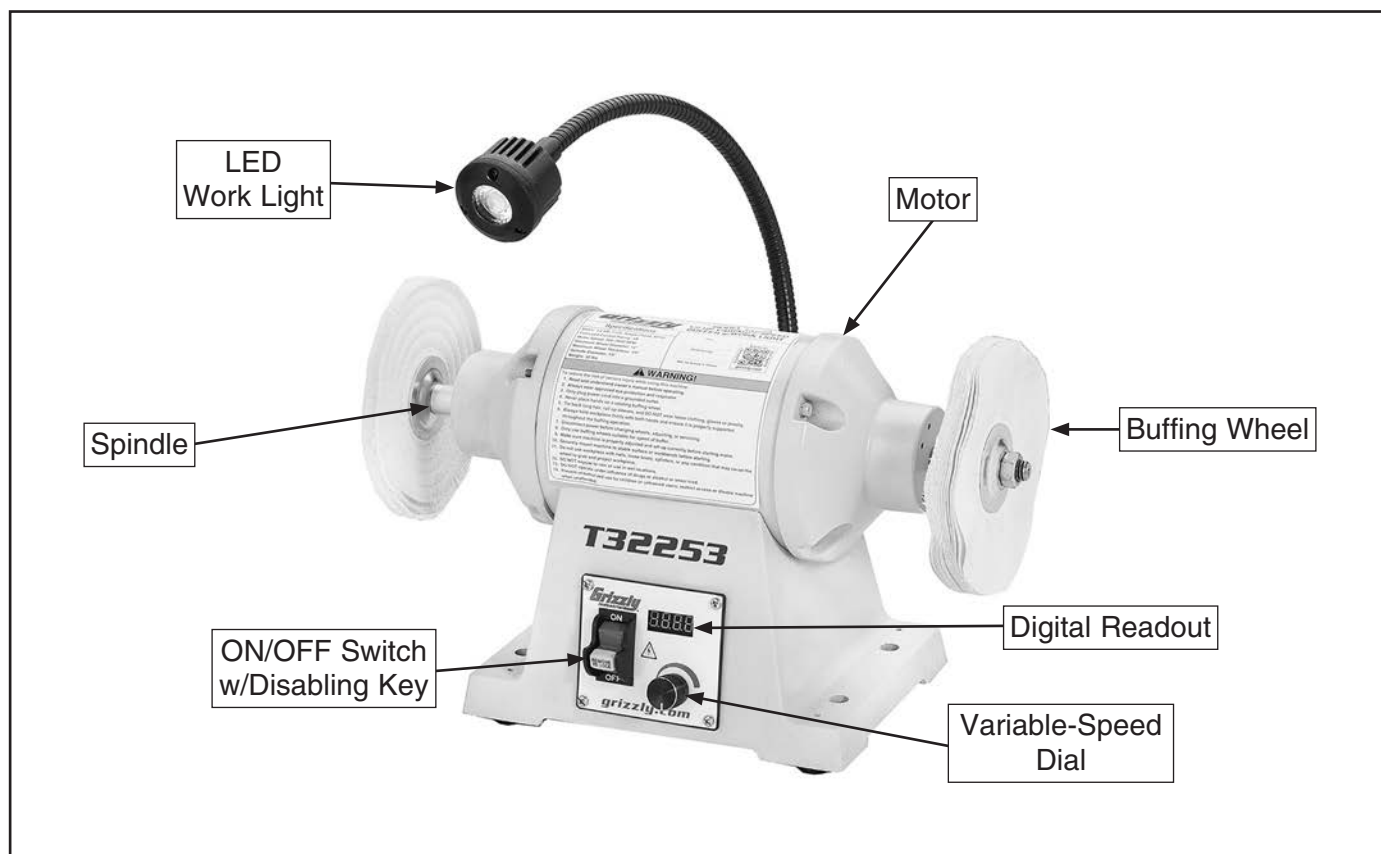
		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Adjust safety devices correctly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not operate if you are tired, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		

Manufactured for Grizzly in Taiwan



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



Controls & Components



Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Buffing Wheel Components

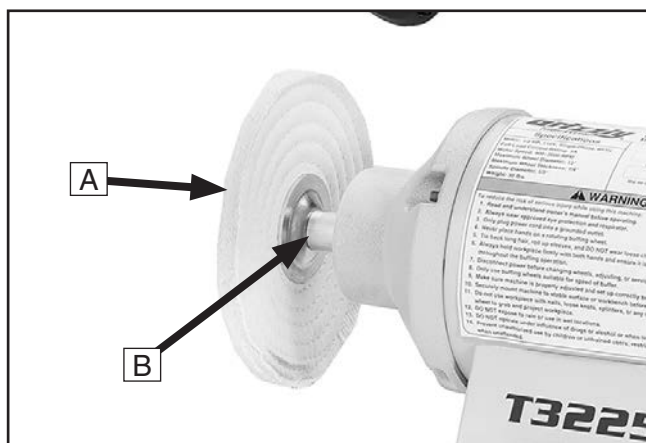


Figure 1. Buffing wheel components.

- A. Buffing Wheel:** Spins to buff workpiece. Can be replaced with different buffing/polishing wheels for different operations and compounds.
- B. Spindle:** Secures and spins buffing wheels. T32253 accepts wheels up to 12" in diameter with a 1/2" bore. T32254 accepts wheels up to 14" in diameter with a 5/8" bore.

Electrical Components

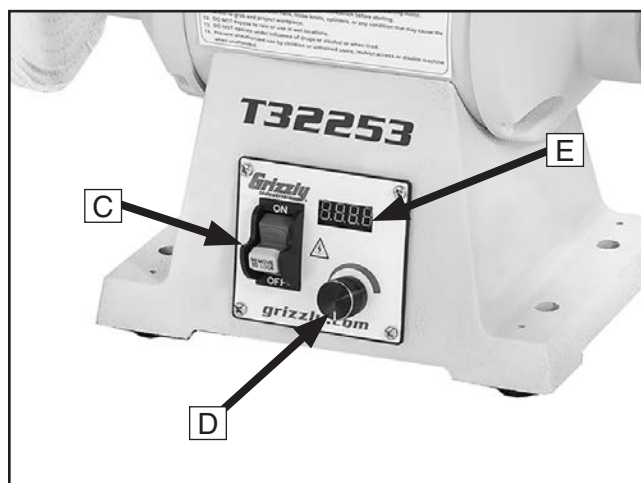


Figure 2. Control panel components.

- C. ON/OFF Switch w/Disabling Key:** Turns motor **ON** when moved up; turns motor **OFF** when moved down. When key is removed, switch is disabled and machine cannot start.
- D. Variable-Speed Dial:** Rotates to adjust buffing speed. Variable-speed dial must be turned fully counterclockwise for motor to start.
- E. Digital Readout:** Displays spindle RPM.



Figure 3. LED work light.

- F. LED Work Light:** Illuminates buffing area for better visibility. Turns **ON** when machine is turned **ON** and adjusts to desired position.





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL T32253 1/2 HP VARIABLE-SPEED BUFFER WITH WORK LIGHT

Product Dimensions:

Weight..... 30 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 16-1/2 x 12 x 18 in.
Footprint (Length x Width)..... 10 x 7 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 34 lbs.
Length x Width x Height..... 24 x 17 x 15 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 3A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 18 AWG
Plug Included..... Yes
Included Plug Type..... NEMA 5-15
Switch Type..... Toggle ON/OFF w/Disabling Key

Motors:

Main

Horsepower..... 1/2 HP
Phase..... Single-Phase
Amps..... 3A
Speed..... 900 - 3600 RPM
Type..... Induction
Power Transfer Direct
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Buffer Type..... Benchtop
Right Wheel Material..... Loose Muslin
Left Wheel Material..... 40-Ply Soft Muslin
Right Wheel Diameter..... 6 in.
Left Wheel Diameter..... 6 in.
Maximum Wheel Diameter..... 12 in.
Right Wheel Thickness..... 1/4 in.
Left Wheel Thickness..... 1/4 in.
Maximum Wheel Thickness..... 1/4 in.
Wheel Bore..... 1/2 in.



Spindle

Spindle Speed..... 900 - 3600 RPM
Spindle Diameter..... 1/2 in.
Spindle Thread Pitch..... 11 TPI
Spindle Length (Usable)..... 11/16 in.
Right Spindle Thread Direction..... Right-Handed
Left Spindle Thread Direction..... Left-Handed
Included Spacers..... 9/16 in.

Construction

Base..... Cast Iron
Work Rest..... Steel
Lamp..... LED
Paint/Finish..... Powder Coated

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Serial Number Location Machine ID Label
ISO 9001 Factory Yes

Features:

Spindle Speed Digital Readout
Variable-Speed Dial
Adjustable LED Work Light
Cast Iron Base





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL T32254 1 HP VARIABLE-SPEED BUFFER WITH WORK LIGHT

Product Dimensions:

Weight..... 42 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 19-1/2 x 12 x 17 in.
Footprint (Length x Width)..... 10 x 7-1/2 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 47 lbs.
Length x Width x Height..... 24 x 17 x 15 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 6A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... NEMA 5-15
Switch Type..... Toggle ON/OFF w/Disabling Key

Motors:

Main

Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 6A
Speed..... 900 - 3600 RPM
Type..... Induction
Power Transfer..... Direct
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Buffer Type..... Benchtop
Right Wheel Material..... Loose Muslin
Left Wheel Material..... 40-Ply Soft Muslin
Right Wheel Diameter..... 8 in.
Left Wheel Diameter..... 8 in.
Maximum Wheel Diameter..... 14 in.
Right Wheel Thickness..... 1/4 in.
Left Wheel Thickness..... 1/4 in.
Maximum Wheel Thickness..... 1/4 in.
Wheel Bore..... 5/8 in.
Minimum Wheel Speed Rating..... 3600 RPM



Spindle

Spindle Speed..... 900 - 3600 RPM
Spindle Diameter..... 5/8 in.
Spindle Thread Pitch..... 11 TPI
Spindle Length (Usable)..... 1 in.
Right Spindle Thread Direction..... Right-Handed
Left Spindle Thread Direction..... Left-Handed
Included Spacers..... 5/8 in.

Construction

Base..... Cast Iron
Lamp..... LED
Paint/Finish..... Powder Coated

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Serial Number Location Machine ID Label
ISO 9001 Factory Yes

Features:

Spindle Speed Digital Readout
Variable-Speed Dial
Adjustable LED Work Light
Cast Iron Base



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery



OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS.

You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly **BEFORE** operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace **BEFORE** operating machine. For your own safety, **DO NOT** operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—**NOT** the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



Additional Safety for Buffers

WARNING

Entanglement/amputation injuries can occur from being caught in moving parts or in-running pinch points. Buffer can easily remove skin. To minimize risk of getting hurt or killed, anyone operating machine **MUST** completely heed hazards and warnings below.

WORKPIECE SELECTION. Always inspect the condition of your workpiece. **DO NOT** buff pieces with loose knots, large splinters, sharp edges, and **DO NOT** buff knives, cable, chain or other potentially dangerous objects that may be grabbed by the buffing wheel and thrown at the operator.

EYE/FACE/LUNG PROTECTION. Always wear eye protection or a face shield and a heavy leather apron when operating the buffer. Wear a dust mask to protect your lungs from microscopic particulates. Particulates may cause allergies or long-term respiratory health problems.

MOUNTING TO BENCH/STAND. An unsecured buffer may become dangerously out of control during operation. Make sure buffer is **FIRMLY** secured to a bench/stand before use.

WORKPIECE CONTROL. If you cannot hold small workpieces securely, do not buff them with this machine. Secure them with clamps or similar jigs or use a different buffer.

AVOIDING ENTANGLEMENT. Becoming entangled in moving parts can cause severe injury or death. Keep all guards and covers in place; **DO NOT** wear loose clothing, gloves, or jewelry; and tie back long hair.

OPERATOR POSITION. Do not stand directly in front of the buffer when turning the machine **ON**, or when buffing. Do not buff material at the rear of the machine.

HAND/WHEEL CONTACT. Do not allow your hands to come into contact with the buffing wheel. Abrasive accessories can remove skin fast. Keep a firm grip on the workpiece and position your hands at a safe distance away when buffing. Avoid wearing gloves as they may get caught in the buffer and cause entanglement injuries.

CORRECT ACCESSORIES AND USE. The buffer is only designed for buffing and polishing. Never exceed the maximum speed listed on each buffing wheel.

WORKPIECE FEED. Allow the wheel to reach full speed, then slowly ease the workpiece into the buffing wheel, holding it in front of and slightly below the wheel center. Do not place the workpiece on the top or sides of the buffing wheel and do not place an edge or corner of the workpiece against the buffing wheel, or jam it against the wheel. The workpiece may eject toward the operator or be torn from the operator's hands, causing serious personal injury.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

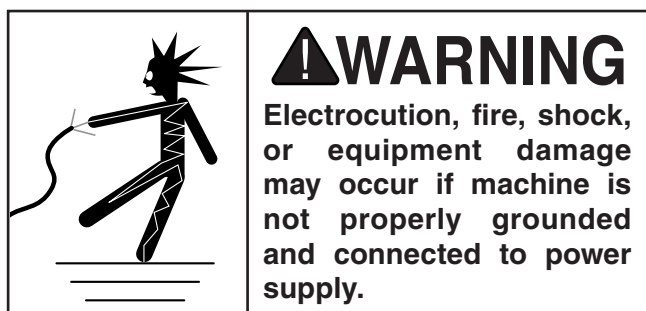
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating (T32253)..... 3 Amps

Full-Load Current Rating (T32254)..... 6 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

!WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

110V Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

!CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*



Grounding & Plug Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

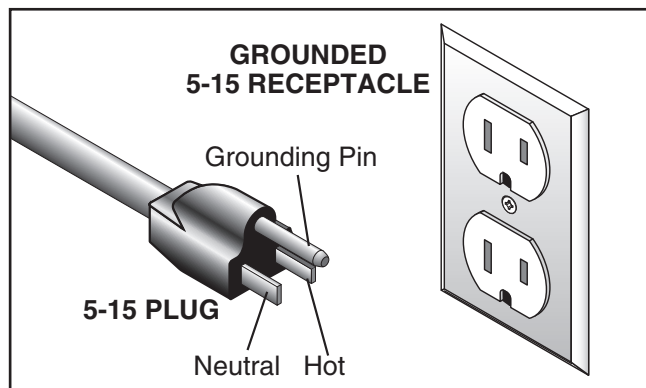
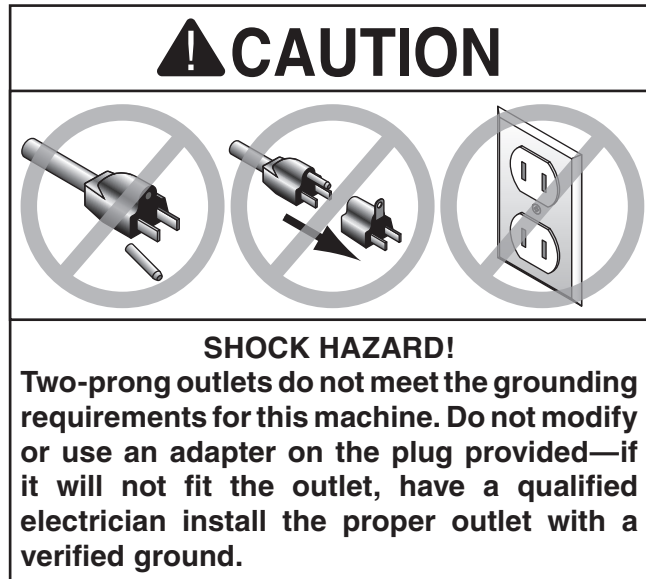


Figure 4. Typical 5-15 plug and receptacle.



Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

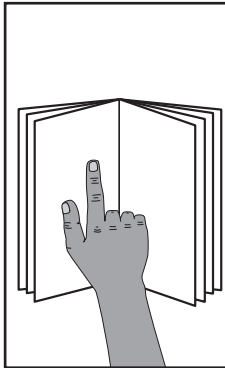
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size (T32253) 16 AWG
Minimum Gauge Size (T32254) 14 AWG
Maximum Length (Shorter is Better).....50 ft.

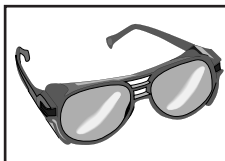


SECTION 3: SETUP



⚠ WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



⚠ WARNING

Wear safety glasses during the entire setup process!

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. ***You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.***

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Safety Glasses	1 Pair
• Solvent/Cleaner	As Needed
• Disposable Rags	1
• Disposable Gloves	1 Pair
• Open-End Wrench $\frac{7}{8}$ " (T32253 Only)	2
• Open-End Wrench $1\frac{1}{16}$ " (T32254 Only)	2

Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Box 1 (Figure 5)	Qty
A. Buffer	1
B. Loose Muslin Wheel 20-Ply	1
C. Spiral Sewn Wheel 40-Ply	1
D. Wheel Flanges	4
E. Spindle Nuts	2
F. Spacers	2

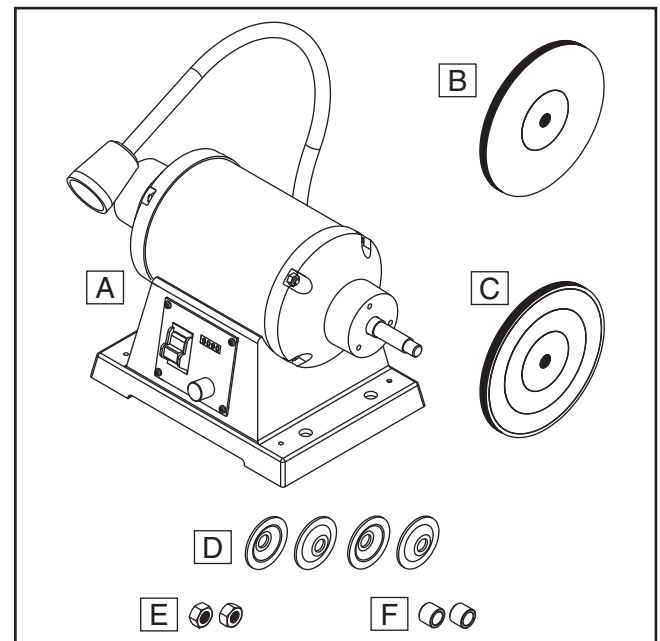


Figure 5. Loose inventory.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

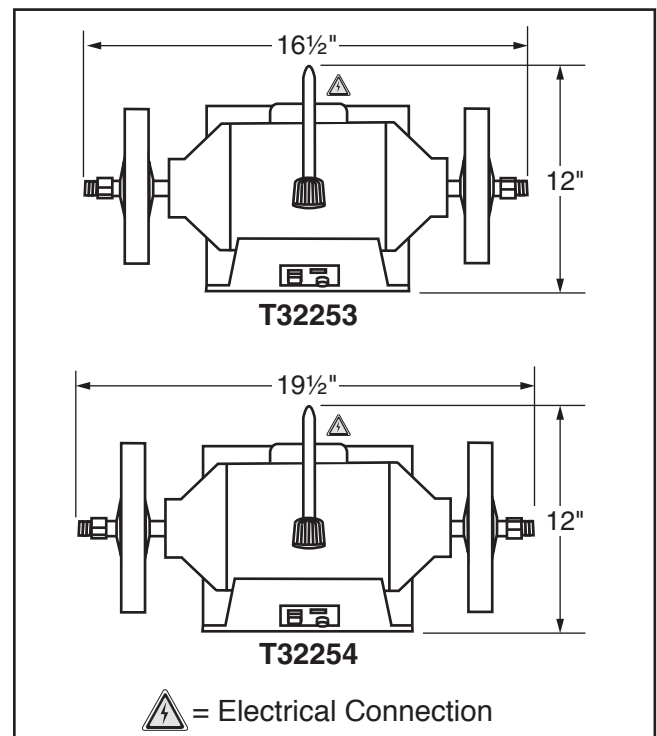
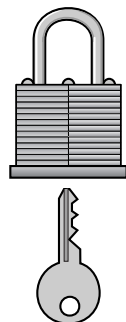


Figure 6. Minimum working clearances.



CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.



Bench Mounting

Number of Mounting Holes 4
Diameter of Mounting Hardware Needed .. 1/2"

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

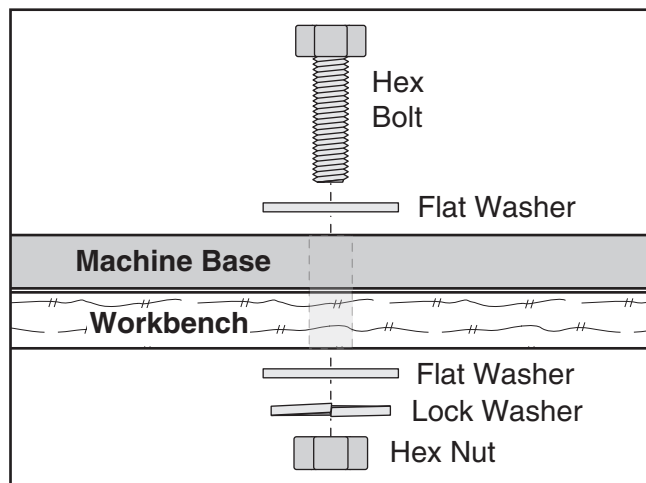


Figure 7. "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

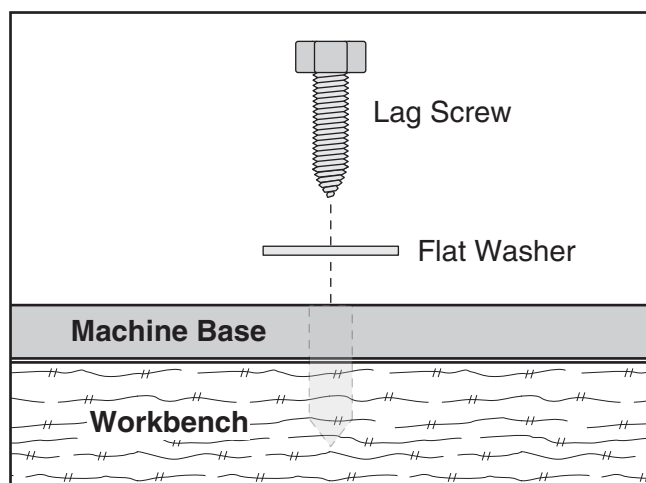


Figure 8. "Direct Mount" setup.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

There is a range of options when it comes to buffing and polishing wheels, but the Model T32253/T32254 comes with two muslin wheels: one loose 20-ply and one spiral sewn 40-ply.

To assemble machine:

1. Place (1) spacer and wheel flange on each spindle shaft on each side of buffer (see **Figure 9**).
2. Install buffing wheels on each spindle shaft (see **Figure 9**).
3. Place (1) wheel flange on each shaft against wheel, and secure each wheel with (1) spindle nut (see **Figure 9**).

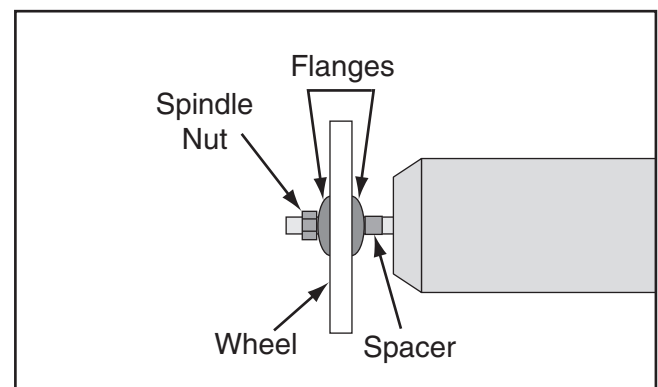


Figure 9. Buffing wheel order of installation.

Note: Left spindle shaft has left-hand threads so install spindle nut with left-hand threads counterclockwise onto shaft.

4. Once both spindle nuts are installed, use a wrench on each to tighten.



Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem **BEFORE** operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the switch disabling key disables the switch properly.

⚠ WARNING

Serious injury or death can result from using this machine **BEFORE** understanding its controls and related safety information. **DO NOT** operate, or allow others to operate, machine until the information is understood.

⚠ WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Turn variable-speed dial all the way counterclockwise and make sure ON/OFF switch is in OFF position (see **Figure 10**).

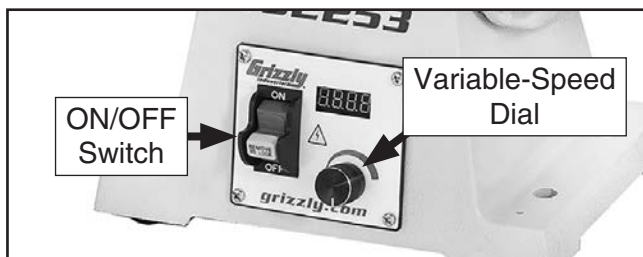


Figure 10. Control panel components.

3. Connect machine to power supply.
4. Move ON/OFF switch up to turn machine **ON** (see **Figure 10**). Work light should illuminate.

Note: Motor will not turn **ON** unless variable-speed dial is turned all the way counterclockwise.

5. Verify motor operation by slowly turning variable-speed dial clockwise. Rotate dial back and forth to test variable-speed function.

Motor should run smoothly and without unusual vibrations or noises.

6. Turn variable-speed dial all the way counterclockwise, then move ON/OFF switch down to turn motor **OFF**.
7. Remove key from toggle switch, as shown in **Figure 11**.

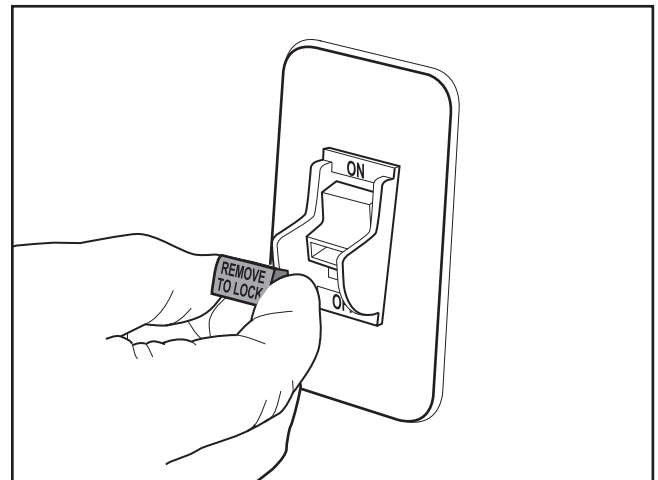


Figure 11. Removing key from toggle switch.

8. Try to start machine with switch.
 - If the machine *does not* start, the toggle switch is working correctly. Congratulations! The Test Run is complete.
 - If the machine *does* start (with the toggle switch removed), immediately disconnect power to the machine. The toggle switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

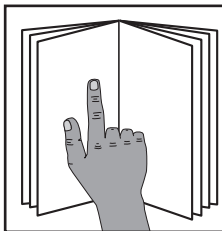


SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



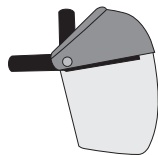
WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.



WARNING

Eye and face injuries and respiratory problems can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



NOTICE

If you are not experienced with this type of machine, **WE STRONGLY RECOMMEND** that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Cleans and examines workpiece to make sure it is suitable for buffing.
2. Selects appropriate polishing compound and buffing wheel.
3. Ensures that variable-speed dial is turned all the way counterclockwise and ON/OFF switch is in OFF position.
4. Connects buffer to power.
5. Puts on personal protective equipment.
6. Stands aside, starts machine, adjusts speed, then applies polishing compound and gradually feeds workpiece into wheel.
7. Stops machine once buffing operation is complete.



Disabling Switch

The switch can be disabled by removing the key, as shown below. Disabling the switch in this manner can prevent unauthorized operation of the machine, which is important if it is not kept inside an access-restricted building or in a location where children may be present.

IMPORTANT: Disabling the switch only restricts its function. It is not a substitute for disconnecting machine from power when adjusting or servicing.

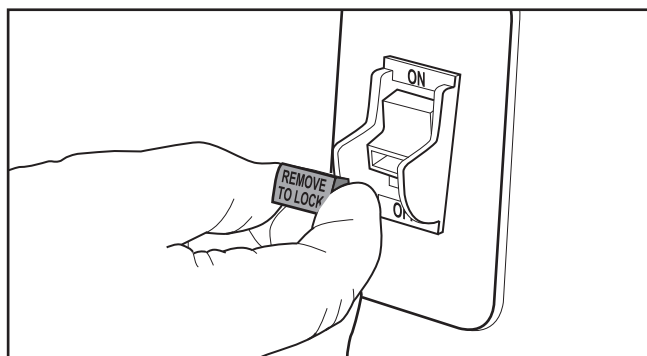


Figure 12. Disabling switch by removing key.

WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, always disable switch before leaving machine unattended. Make sure to place key in a well-hidden or secure location!

Buffing

Below are some quick tips for getting the most out of your buffing wheels. Remember, there is no substitute for experience. Learning how to hold the workpiece, how much pressure to apply, how to move the workpiece against the wheel, and how much compound to use requires a certain amount of trial-and-error.

- Thoroughly clean all parts you plan to buff. Dirt, oil, rust, paint, or other film must be removed chemically or with water. Make sure to dry off parts with a rag after cleaning.
- Apply buffing compounds in small amounts at a time. Apply paste-type compounds with a wand or directly to the part. For wax-based polishing stick-type compounds, press compound on the wheel for a couple of seconds while machine is running. Avoid using too much compound.
- Put your workpiece under wheel when you are loading compound on the buffing wheel. This way, you will catch any compound that would normally be wasted on floor.
- To begin buffing, slowly feed workpiece into buffing wheel workpiece contact zone (see **Figure 13**). Contacting workpiece on areas outside of the correct area may flip workpiece out of your hands. Hold workpiece tightly at all times while buffing. Placing one hand near contact point will give you better control.

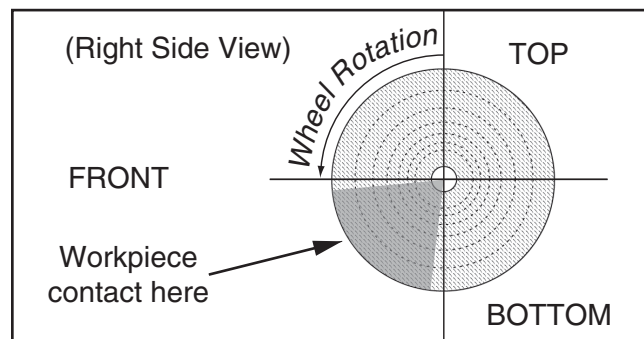


Figure 13. Workpiece contact zone.



- Keep buffing wheels raked out before each use and when buildup gets heavy during use. Raking means to clean buffing wheels with a wheel rake to remove built-up compounds and metal particles. ALWAYS use light pressure when raking wheels!
- Do not mix two different compounds on same wheel. For best results, use a separate wheel for each compound.
- Always use an upward stroke with heavy to moderate pressure for cutting. Use a downward stroke with light pressure for polishing (see **Figure 14**).

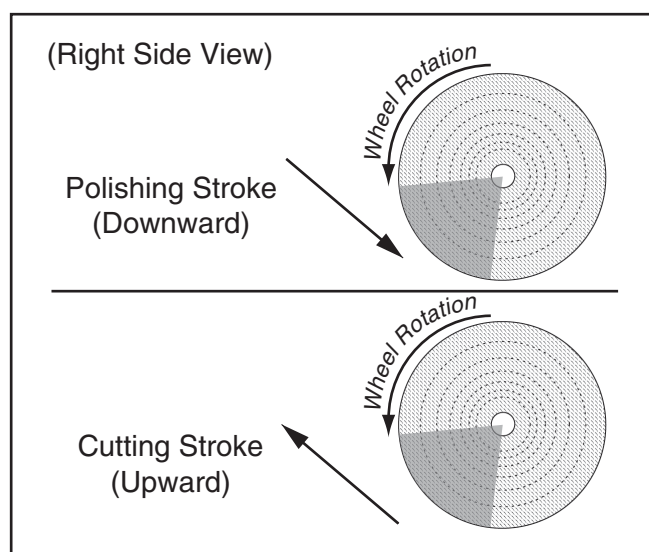


Figure 14. Cutting and polishing strokes.

- Wear safety equipment when buffing. If polisher forces workpiece out of your hand, be prepared for it to come flying at you! Wear safety glasses or a face shield and a heavy leather apron. Also, wear a dust mask to protect your lungs from microscopic particulate that will be flying off wheel.

NOTICE

Use caution when polishing plated metals; there is a chance that thinly-plated materials could be damaged. Light pressure is all that is needed for quality work.

Selecting Buffing Wheels

Buffing wheels are available for most types of metals, some woods, and for different stages in the buffing process. Below are pictures and descriptions of common wheel types.

⚠ CAUTION

Only use buffing wheels with a wheel speed rating higher than RPM buffer is capable of.

Loose Domet

Full sheets of domet flannel without any stitch webbing for final polishing. Designed specifically for polishing guitars, drums, and other instruments made of wood.



Loose Muslin

Soft feather-edged muslin stitched together near the center leaves the outer edge to provide a wide angle, fine polishing surface. Perfect for polishing stainless steel, chrome, gold or silver.



Airway Hard

Made of 100% cotton sheets that are treated to stiffen the material. Pleats in the material help hold compound. These are great for rough cutting plastics and initial polishing a wide variety of metals.



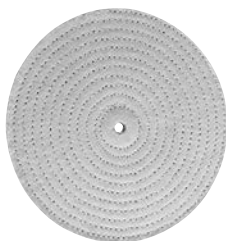
Airway Soft

Made of 100% cotton sheets and held together with a steel retainer. Pleats in the material help hold compound. These wheels are great for polishing soft metals and plastics.



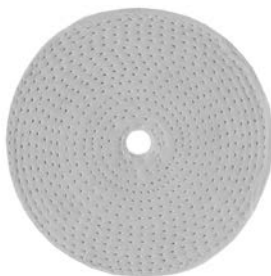
Laminated Sisal

Designed for rough cutting, sisal works well with various steels, copper, aluminum, and brass to remove scratches and prepare the piece for polishing.



Spiral Sewn

Consist of layers of 100% unbleached cotton sheeting that are spiral sewn 1/8" apart. Works well for initial polish on brass, stainless steel, aluminum, bronze and cast iron.



Buffing Wheel Sequence Key

Buff Style	Plastics Soft Metals			Thin Plating Gold Silver			Chrome & Nickel Plate			Copper Brass Aluminum			Iron Steel Stainless Steel		
	R	F	P	R	F	P	R	F	P	R	F	P	R	F	P
Loose Muslin-Soft			X			X			X			X			X
Loose Muslin-Hard										X		X	X		
Airway Hard	X									X		X			
Airway Soft		X			X			X			X				
Laminated Sisal									X				X		
Spiral Sewn		X					X			X				X	

Buffing Sequence: R = Rough F= Final Cut, Initial Polish P = Final Polish

Installing/Removing Buffing Wheel

The spindle shafts protruding from either side of the motor make it easy to swap out different buffing wheels for different projects. Install the muslin wheels that came with your buffer or one appropriate for your operation. The T32253 accepts wheels with a 1/2" bore while the T32254 requires a 5/8" bore.

Tools Needed

Qty

Open-End Wrenches 7/8" (T32253 Only) 2
Open-End Wrenches 1 1/16" (T32254 Only) 2

To install/remove buffing wheel:

1. DISCONNECT MACHINE FROM POWER!
2. Remove spindle nut and outer flange from each spindle shaft (see **Figure 15**). DO NOT remove inner flange or spacer.

Note: Left spindle shaft has left-hand threads so hex nut threads counterclockwise onto shaft.

3. Remove old buffing wheels (if installed) and install desired buffing wheels between inner and outer wheel flanges (see **Figure 15**).

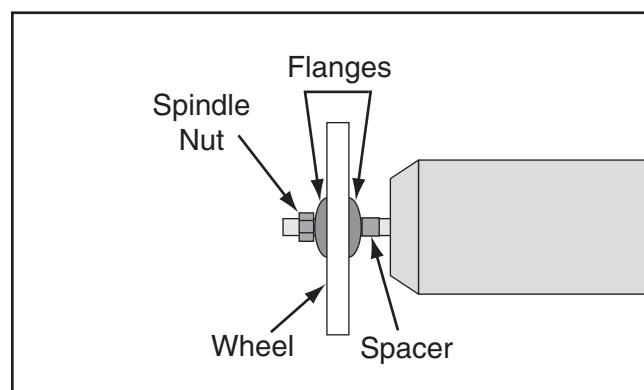


Figure 15. Buffing wheel order of installation.

4. Secure wheels and flanges with spindle nuts removed in **Step 2**.



Selecting Buffing Compounds

Most colors of abrasives have similar applications, but always check with the manufacturer of your particular compound.

Grizzly offers the following compounds:

Red Rouge — Made for fine polishing on brass and gold. Provides an excellent shine when used with the loose muslin buffing wheel.

Green (Extra Fine) — Great for extra-fine polishing on most metals to bring out that mirror finish. Works best with loose muslin and spiral sewn buffing wheels.

White — Great for ivory, plastic and resins when used successively with the soft spiral sewn and soft airway buffing wheels.

Black — Designed to be used with sisal and airway hard buffing wheels, this compound is perfect for the initial rough cut on stainless steel and iron.

Tripoli — A true middle-of-the-road abrasive, Tripoli provides an excellent medium cut for brass, aluminum and zinc alloy.

Green (Fine) — Slightly more abrasive than the extra-fine green, this green compound is great for a medium-to-fine polish with most softer metals.

Buffing Compound Sequence Key

Compound Type	Plastics Soft Metals			Thin Plating Gold Silver			Chrome & Nickel Plate			Copper Brass Aluminum			Iron Steel Stainless Steel		
	R	F	P	R	F	P	R	F	P	R	F	P	R	F	P
Tripoli	X							X		X					
Dark Rouge						X		X		X	X				X
White Rouge		X	X												
Black Rouge													X	X	

Buffing Sequence: R = Rough F= Final Cut, Initial Polish P = Final Polish

Loading Compound

Select a buffing compound and buffing wheel that is suitable for the workpiece and each sequence of the buffing or polishing operation.

To load compound on wheels:

1. Select buffing wheel suitable for workpiece (refer to **Selecting Buffing Wheels** on **Page 20**). Follow directions on **Page 21** to install wheel.
2. Select buffing compound suitable to material (refer to **Selecting Buffing Compounds** and **Buffing Compound Sequence Key**).

Note: Make sure buffing wheel is free of any compound used in prior buffing operation. Clean with a buffing wheel rake if necessary (see **Cleaning** on **Page 24**).

3. Put on safety glasses, face shield, and respirator, then connect machine to power.
4. Stand to side of buffing wheel and turn machine **ON**. Allow wheel to reach full speed.
5. Apply buffing compound to rotating face of wheel, as shown in **Figure 16**. Only hold compound to wheel for 2–5 seconds. The polisher is now ready for buffing/polishing.

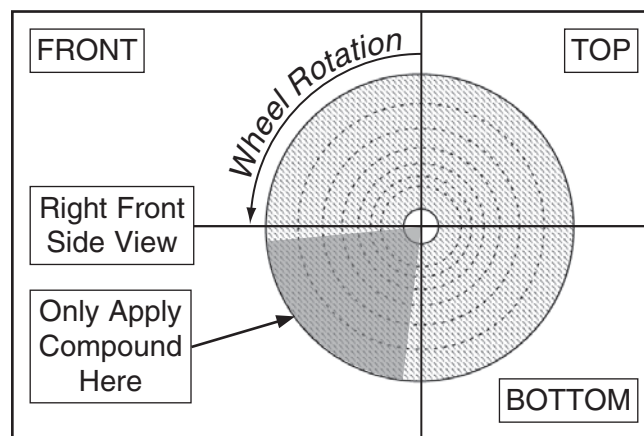


Figure 16. Location where buffing compound should contact wheel.

6. Turn machine **OFF** when operation is complete.



SECTION 5: ACCESSORIES

!WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

G2582—Buffing Compound Set

Set includes one 5 oz. bar of each of the following compounds: Black Emery Cake, Tripoli Brown rouge, White Rouge & Red Rouge. Low cost – must have! Due to their nature, colors may vary.

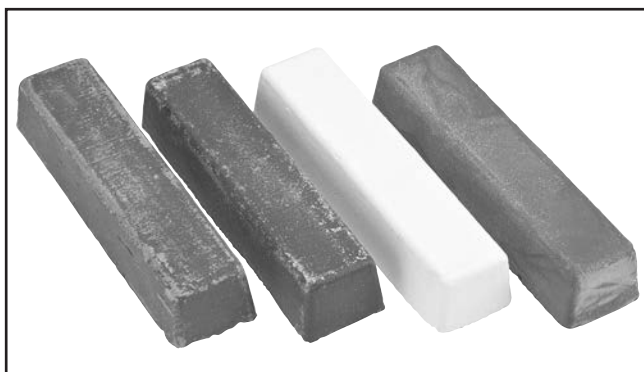


Figure 17. Model G2582 Buffing Compound Set.

H0813—Menzerna Yellow Compound

Fine-polishing compound for an excellent high-gloss finish on all wood coatings and plastics. Designed to polish at a low-working temperature to prevent hazing of lacquer or plastic burning. Use with a Domet flannel buffing wheel.



Figure 18. Model H0813 Menzerna Yellow Fine Polishing Compound.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T32253 Buffing Wheels

MODEL	TYPE	SIZE	MAX RPM
D2512	Soft Muslin	5" x 40 Ply x ½"	5,000
D2513	Soft Muslin	6" x 40 Ply x ½"	5,000
D2514	Hard Muslin	6" x 50 Ply x ½"	5,000
D2515	Airway Hard	6" x 12 Ply x ½"	3,500
D2518	Airway Soft	6" x 12 Ply x ½"	3,500
D2506	Spiral Sewn	5" x 60 Ply x ½"	5,000
D2498	Spiral Sewn	6" x 30 Ply x ½"	4,000
D2507	Spiral Sewn	6" x 60 Ply x ½"	4,000

T32254 Buffing Wheels

MODEL	TYPE	SIZE	MAX RPM
D3188	Soft Muslin	5" x 40 Ply x ⅝"	5,000
D3190	Soft Muslin	8" x 40 Ply x ⅝"	4,000
D3191	Hard Muslin	6" x 50 Ply x ⅝"	4,000
D3192	Hard Muslin	8" x 50 Ply x ⅝"	4,000
D3193	Airway Hard	6" x 12 Ply x ⅝"	3,500
D3194	Airway Soft	6" x 12 Ply x ⅝"	3,500
D3177	Spiral Sewn	4" x 30 Ply x ⅝"	5,000
D3184	Spiral Sewn	6" x 60 Ply x ⅝"	4,000
D3182	Spiral Sewn	8" x 40 Ply x ⅝"	4,000

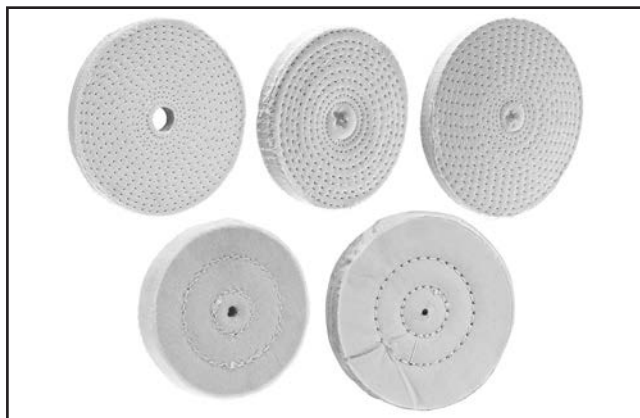
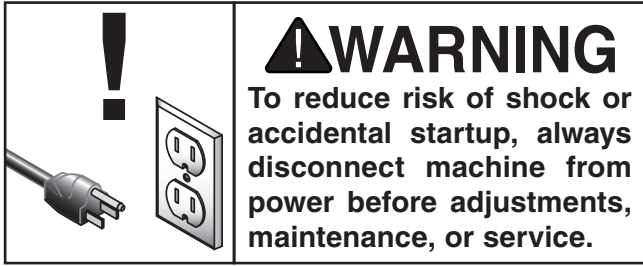


Figure 19. Replacement buffing wheels.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Damaged spindle shaft.
- Damaged buffing wheels.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance

- Inspect cord for wear/damage.
- Inspect ON/OFF switch for wear/damage.
- Inspect variable-speed dial for wear/damage.

Monthly Check

- Clean/vacuum dust buildup off motor.

Lubrication

The bearings inside the Model T32253/T32254 are sealed and permanently lubricated. Simply leave them alone unless they need replacing.

Cleaning

Cleaning the Model T32253/T32254 is relatively easy. Vacuum excess debris and wipe off the remaining dust with a dry cloth. Wipe down spindle with a non-staining lubricant after cleaning.

To clean buffing wheels, use a buffing wheel rake to remove dried compound. Guide the rake across the spinning buffing wheel using light pressure, as shown in **Figure 20**.



Figure 20. Removing compound from buffing wheel with buffing wheel rake.

See below for some rake accessories available through Grizzly.

H4383—Buffing Wheel Rake with Handle

H4384—Replacement Rake

Great for removing dried compound from buffing wheels. Simply guide the rake across the spinning buff.

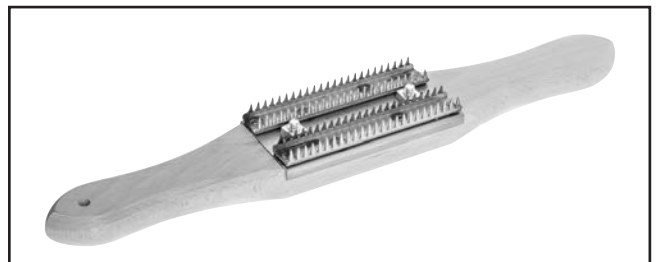


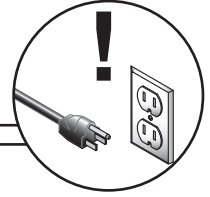
Figure 21. Buffing wheel rake with handle.



SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Switch disabling key removed. 2. Blown fuse. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Wiring broken, disconnected, or corroded. 6. ON/OFF switch at fault. 7. Circuit boards at fault. 8. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Replace fuse/ensure no shorts. 3. Ensure correct power supply voltage and circuit size. 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Fix broken wires or disconnected/corroded connections. 6. Replace switch. 7. Inspect/replace if at fault. 8. Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Machine undersized for task. 2. Buffing wheel too large/wide or exceeds recommended wheel rating. 3. Motor overheated. 4. Circuit board at fault. 5. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Use new buffing wheel; reduce feed rate. 2. Replace with smaller wheel or reduce wheel width. 3. Clean motor, let cool, and reduce workload. 4. Test/replace circuit board. 5. Replace motor.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Buffing wheel loose or worn. 2. Motor or component loose. 3. Incorrectly mounted to workbench. 4. Motor shaft bent. 5. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Re-install (Page 21) or replace buffing wheel. 2. Replace damaged/missing fasteners; tighten if loose. 3. Adjust feet, shim, or tighten mounting hardware. 4. Test with dial indicator and replace motor. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> 1. Operator using too much pressure. 2. RPM too low. 	<ol style="list-style-type: none"> 1. Use less pressure when buffing. 2. Increase buffing wheel RPM.
Poor results from buffing/polishing operation.	<ol style="list-style-type: none"> 1. Workpiece contains residue or contaminants. 2. Contaminated buffing compounds on wheel. 3. Wrong buffing compound for material. 4. Workpiece not held firmly. 5. Incorrect stroke for buffing compound/wheel/material. 6. Incorrect type of buffing wheel for material. 	<ol style="list-style-type: none"> 1. Dirt, oil, rust, paint, or other film must be removed chemically or with water. Dry parts before buffing. 2. DO NOT mix different compounds on same wheel. Use separate wheel for each compound. Remove compound with buffing wheel rake (Page 24). 3. Use correct buffing compound (Page 22). 4. Use a holding device to firmly secure workpiece. 5. Use upward stroke with heavy pressure for cutting; downward stroke with light pressure for polishing. 6. Use correct buffing wheel (Page 20).



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.











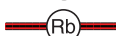

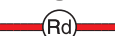

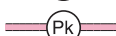
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	RED 	TURQUOISE 
RED 	ORANGE 	PINK 	



T32253 Wiring Diagram

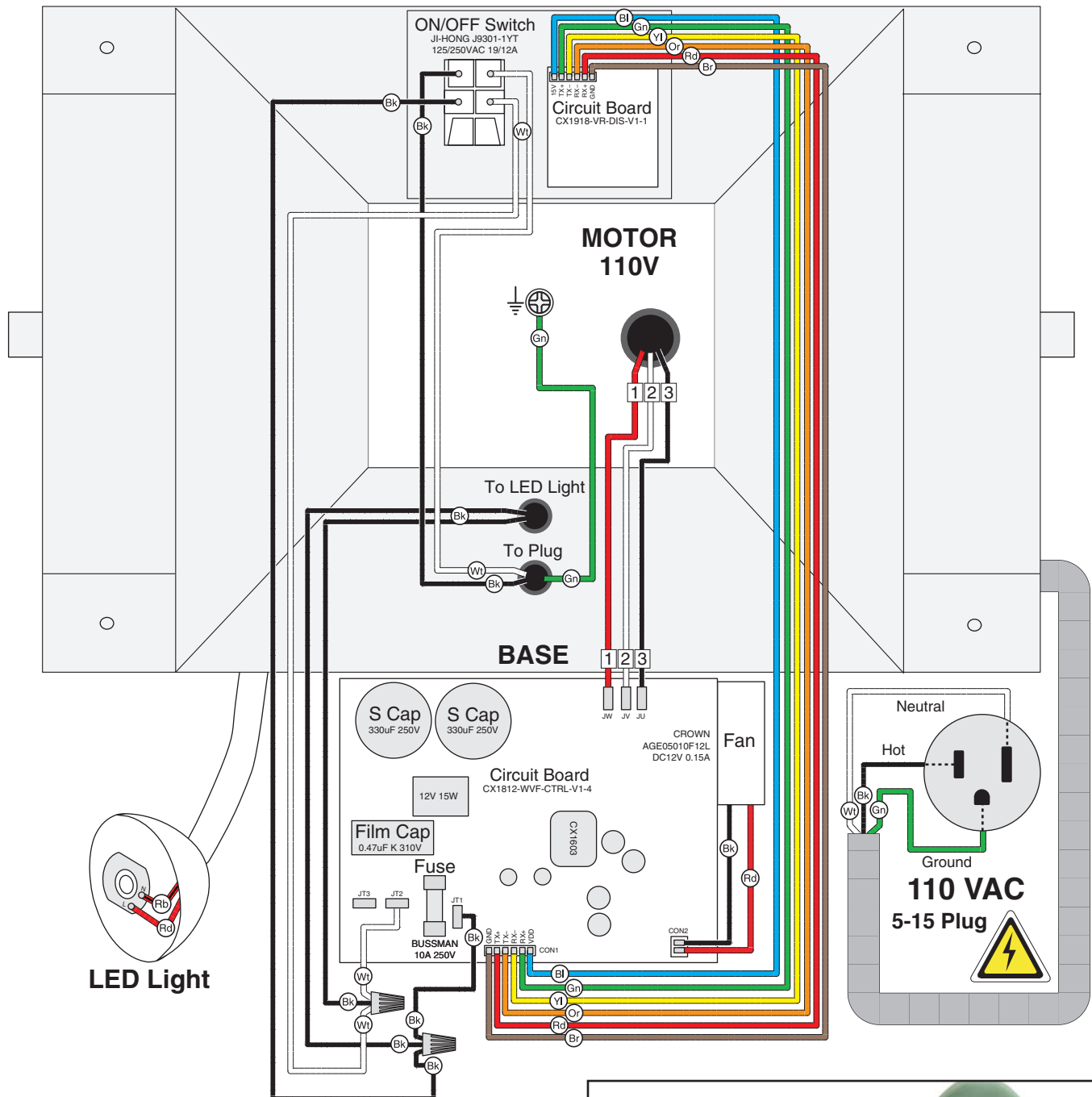


Figure 22. T32253 start capacitors.

T32254 Wiring Diagram

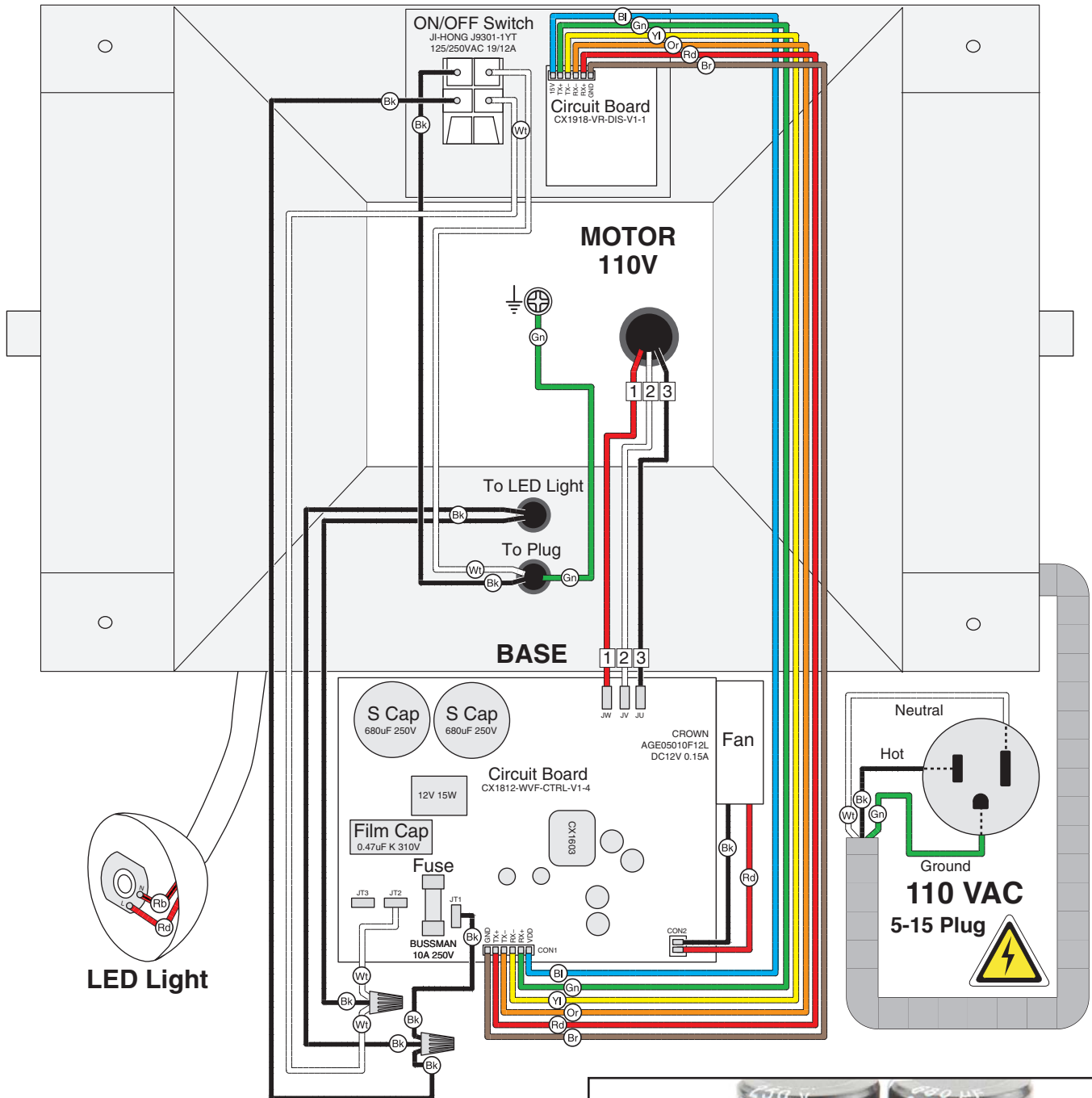


Figure 23. T32254 start capacitors.



Electrical Component Photos



Figure 24. T32253 switch wiring.

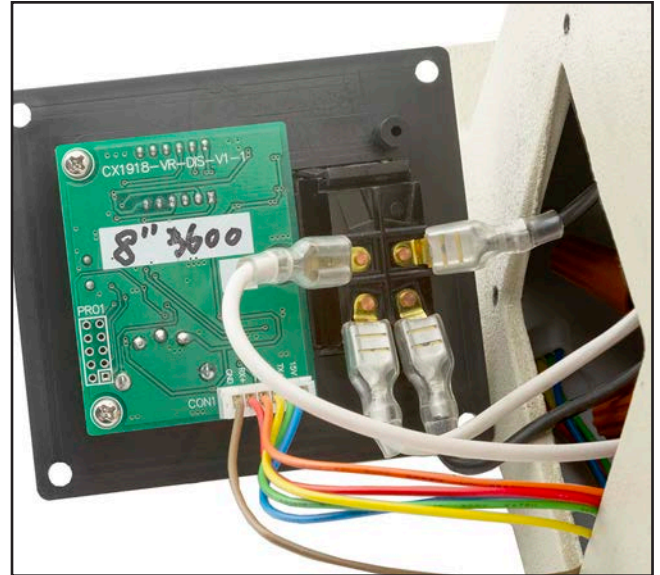


Figure 26. T32254 switch wiring.

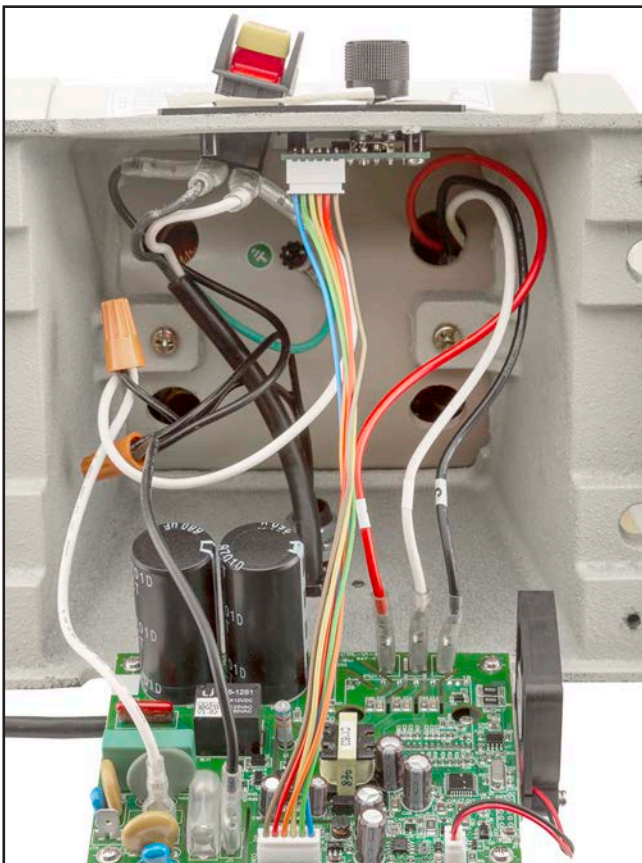


Figure 25. Control unit wiring.

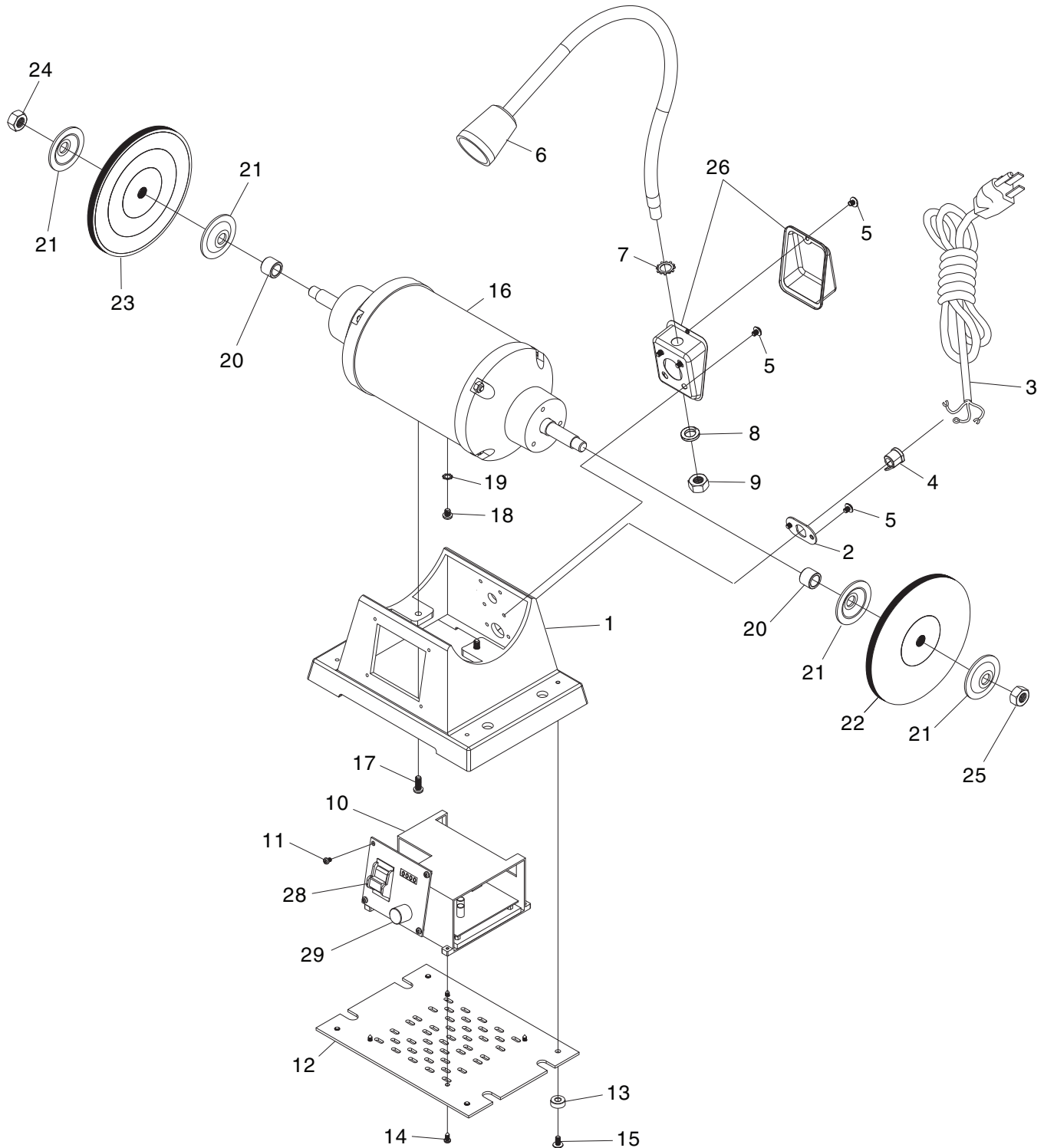


Figure 27. LED wiring.

SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

Main



T32253 Parts List

REF	PART #	DESCRIPTION
1	PT32253001	BASE
2	PT32253002	CORD PLATE
3	PT32253003	POWER CORD 18G 3W 72" 5-15P
4	PT32253004	STRAIN RELIEF TYPE-1 1/2
5	PT32253005	FLANGE SCREW 10-24 X 1/4
6	PT32253006	WORK LIGHT ASSEMBLY
7	PT32253007	EXT TOOTH WASHER 1/2
8	PT32253008	LOCK WASHER 1/2
9	PT32253009	HEX NUT 1/2-18
10	PT32253010	CONTROL PANEL UNIT
11	PT32253011	PHLP HD SCR M4-.7 X 6
12	PT32253012	BASE PLATE
13	PT32253013	RUBBER FOOT
14	PT32253014	TAP SCREW M3.5 X 10

REF	PART #	DESCRIPTION
15	PT32253015	FLANGE SCREW 10-24 X 3/8
16	PT32253016	MOTOR 1/2HP 110V 1-PH
17	PT32253017	PHLP HD SCR M6-1 X 16
18	PT32253018	PHLP HD SCR M5-.8 X 6
19	PT32253019	EXT TOOTH WASHER 5MM
20	PT32253020	SPACER 13 X 19 X 15
21	PT32253021	WHEEL FLANGE
22	PT32253022	BUFFING WHEEL 6" X 1/4" X 1/2" 20-PLY
23	PT32253023	BUFFING WHEEL 6" X 1/4" X 1/2" 40-PLY
24	PT32253024	HEX NUT 1/2-13 LH
25	PT32253025	HEX NUT 1/2-13
26	PT32253026	JUNCTION BOX
28	PT32253028	ON/OFF SWITCH JI-HONG J9301-1YT
29	PT32253029	VARIABLE-SPEED DIAL

T32254 Parts List

REF	PART #	DESCRIPTION
1	PT32254001	BASE
2	PT32254002	CORD PLATE
3	PT32254003	POWER CORD 16G 3W 72" 5-15P
4	PT32254004	STRAIN RELIEF TYPE-1 1/2
5	PT32254005	FLANGE SCREW 10-24 X 1/4
6	PT32254006	WORK LIGHT ASSEMBLY
7	PT32254007	EXT TOOTH WASHER 1/2
8	PT32254008	LOCK WASHER 1/2
9	PT32254009	HEX NUT 1/2-18
10	PT32254010	CONTROL PANEL UNIT
11	PT32254011	PHLP HD SCR M4-.7 X 6
12	PT32254012	BASE PLATE
13	PT32254013	RUBBER FOOT
14	PT32254014	TAP SCREW M3.5 X 10

REF	PART #	DESCRIPTION
15	PT32254015	FLANGE SCREW 10-24 X 3/8
16	PT32254016	MOTOR 1HP 110V 1-PH
17	PT32254017	PHLP HD SCR M6-1 X 16
18	PT32254018	PLHP HD SCR M5-.8 X 6
19	PT32254019	EXT TOOTH WASHER 5MM
20	PT32254020	SPACER 16 X 22 X 16
21	PT32254021	WHEEL FLANGE
22	PT32254022	BUFFING WHEEL 8" X 1/4" X 5/8" 20-PLY
23	PT32254023	BUFFING WHEEL 8" X 1/4" X 5/8" 40-PLY
24	PT32254024	HEX NUT 5/8-11 LH
25	PT32254025	HEX NUT 5/8-11
26	PT32254026	JUNCTION BOX
28	PT32253028	ON/OFF SWITCH JI-HONG J9301-1YT
29	PT32253029	VARIABLE-SPEED DIAL



Labels & Cosmetics

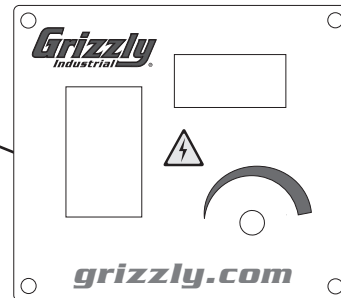
 MODEL T32253 1/2 HP VARIABLE-SPEED BUFFER w/WORK LIGHT	
Specifications Motor: 1/2 HP, 110V, Single-Phase, 60 Hz Full-Load Current Rating: 3A Motor Speed: 900-3600 RPM Maximum Wheel Dia. x Width: 12" x 1/4" Spindle Diameter: 1/2" Weight: 30 lbs.	Date _____ Serial Number _____ Mfd. for Grizzly in Taiwan 
⚠ WARNING! To reduce the risk of serious injury while using this machine: 1. Read and understand owner's manual before operating. 2. Always wear approved eye protection and respirator. 3. Only plug power cord into a grounded outlet. 4. Never place hands on a rotating buffing wheel. 5. Tie back long hair, roll up sleeves, and DO NOT wear loose clothing, gloves or jewelry. 6. Always hold workpiece firmly with both hands throughout the buffing operation. 7. Disconnect power before changing wheels, adjusting, or servicing. 8. Only use buffing wheels suitable for maximum speed of buffer. 9. Make sure machine is properly adjusted and set up correctly before starting motor. 10. Securely mount machine to stable surface or workbench before starting. 11. Do not use workpiece with nails, loose knots, splinters, or any condition that may cause the wheel to grab and project workpiece. 12. DO NOT expose to rain or use in wet locations. 13. DO NOT operate under influence of drugs or alcohol or when tired. 14. Prevent unauthorized use by children or untrained users; restrict access or disable machine when unattended.	

101

102

T32253

104



103

REF	PART #	DESCRIPTION
101	PT32253101	MACHINE ID LABEL (T32253)
101	PT32254101	MACHINE ID LABEL (T32254)
102	PT32253102	TOUCH-UP PAINT, GRIZZLY BEIGE

REF	PART #	DESCRIPTION
103	PT32253103	CONTROL PANEL LABEL
104	PT32253104	MODEL NUMBER LABEL (T32253)
104	PT32254104	MODEL NUMBER LABEL (T32254)

⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

In the event you need to use this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/secureforms/warranty-card>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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